

Work Order ID 80672-1

February-24-12 3:31:04 PM

80672

Page 1

Item ID: D4434-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4434

2

B

ECN 12.537

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 03 15 (10)

12 03 15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 80672

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/17/16

410

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

CSAK

EF 12-03-19
SB 12/03/19

10

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

12 03 19 10

W/O:		WORK ORDER CHANGES					
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10

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

10x4 M/L 12-3-19

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

10x4 M/L 12/03/19

180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg. do not install grommets and rubber seal.

FF (10) 12-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

185

QC5- Inspect part completeness to step on W/O

0.00

185

QC

Memo

0.00

Quality Control

SA 1213/20

10

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Memo

*START: 10h00
CURET: 320F
FINISH: 10h30*

0.00

M115128

Powder Coating

10

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

WXP MIP 15/03/12

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10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

202

0.00

202

Small Fab

Memo

0.00

Small Fab

Install rubber seals and grommets.

3M 1300 batch: 120159

① FF 12-03-20

205

QC5- Inspect part completeness to step on W/O

0.00

205

QC

Memo

0.00

Quality Control

Sp 12/03/20

①

210

Identify as per dwg & Stock Location: 5/110

0.00

210

Packaging

Memo

0.00

Packaging

Sp 12-03-22.

[Signature]

W/O:		WORK ORDER CHANGES					
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Stop ***NS2***

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Start Date: 24/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 12/03/21

MK
12-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 80672

80672

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP revA 11.10.06 new issue EC verified by:DD
 11.12.22 per PA5 EC verified by:JLM
 per REV.A DD verified by:EC
 IPP RevB
 IPP RevC 12.01.24

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

294.9670

2.5

26.31579

**

M 12 03 15

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

294.967

117653

27.91

120154

90

120218

177.057

D4434-9

Manufactured

No

180

Each

1.0000

1

10

**

D4434-9

Bracket

① FF 12-03-20

Location

Loc Qty

Loc Code

GA

1

79508

1

D4435-041

Manufactured

No

180

Each

1.0000

1

10

**

D4435-041

Bracket Assembly

① FF 12-03-20

Location

Loc Qty

Loc Code

ST139B

1

79371

1

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 80672

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

80672

D4434-043

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4441-1

Manufactured No

202

f

24.7270

0.142

1.42

D4441-1

Rubber Seal

**

① FF 12-03-20

Location

Loc Qty

Loc Code

prelim

24.727

24.727

74760

80763

1.42

Cut qty 1 to 1.7"

D4441-1

Manufactured No

f

24.7270

2.08

D4441-1

Rubber Seal

**

① FF 12-03-20

Location

Loc Qty

Loc Code

prelim

24.727

24.727

74760

80763

2.08

Cut qty 1 to 2.5"

D4441-1

Manufactured No

f

24.7270

18.75

D4441-1

Rubber Seal

**

① FF 12-03-20

Location

Loc Qty

Loc Code

prelim

24.727

24.727

74760

B79305

1.875

Cut qty 1 to 22.5"

D4440-1

Manufactured No

202

Each

20.0000

1

10

D4440-1

Grommet

**

① FF 12-03-20

Location

Loc Qty

Loc Code

prelim

2

74759

2

PREst

8

77917

8

ST139F

10

79372

10

8.4

3

February-24-12 3:31:07 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 80672

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

80672

D4434-043

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN525-832R6

Purchased

No

180

Each

511.0000

3

30

AN525-832R6

Screw

**

SB 12/03/20

Location

Loc Qty

Loc Code

ST345

511

120308

11

120560

500

3

MS20426AD3-2

Purchased

No

180

Each

18,319.00

12

120

MS20426AD3-2

Rivet

**

SB 12/03/20

1203.20
QSI 042

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

M119109

MS20426AD3-3

Purchased

No

180

Each

2,749.000

2

20

MS20426AD3-3

Rivet

**

SB 12/03/20

Location

Loc Qty

Loc Code

ST316

2749

119109

2246

19099

503

30

MS20470AD4-3

Purchased

No

180

Each

5,874.000

5

50

MS20470AD4-3

Rivet - Universal Head

**

SB 12/03/20

1203.20
QSI 042

Location

Loc Qty

Loc Code

Mezz

5874

1642

1240

2193

4634

M120518

50

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Shop Packet Print

Page 3

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Work Order ID: 80672

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

80672

D4434-043

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS21075L08

Purchased

No

180

Each

364.0000

7

70

MS21075L 08

ANCHOR NUT

**

Sh 12/03/

Location

Loc Qty

Loc Code

ST303

302

111578

2

120560

300

ST304

62

120121

62

~~111578~~

February-24-12 3:31:07 PM

Shop Packet Print

Page 4

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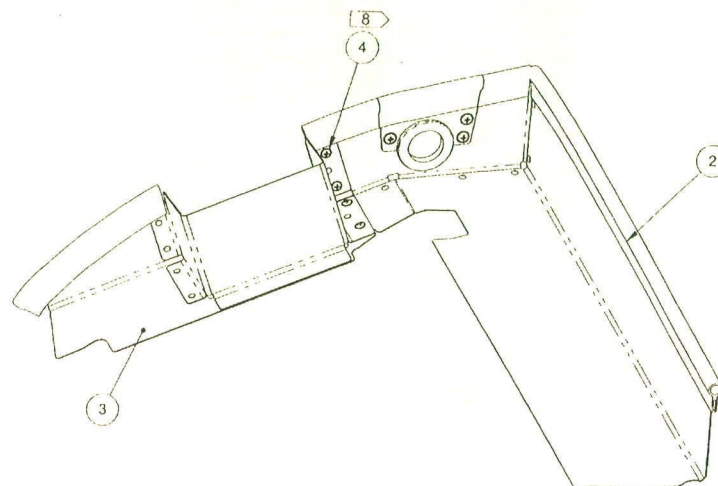
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



W/O 80672

RELEASED
R 2012-05-02
JW

D4434-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

B	RE-DESIGN D4434-01-0F (ZN B5-14, A5-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EB</i>	D4434	SHEET 1 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	COVER ASSEMBLY	NTS
DATE	12.02.22	<small> COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

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8

7

6

5

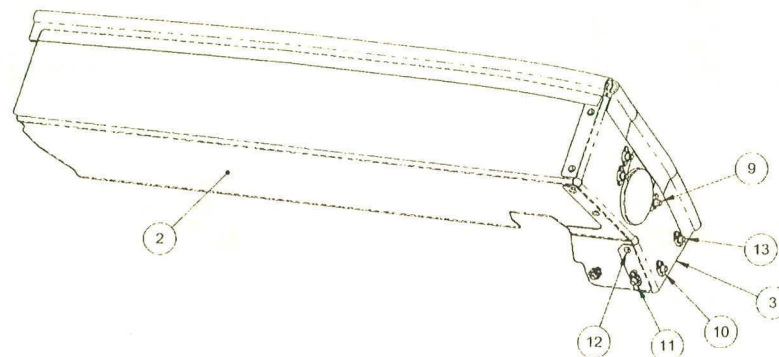
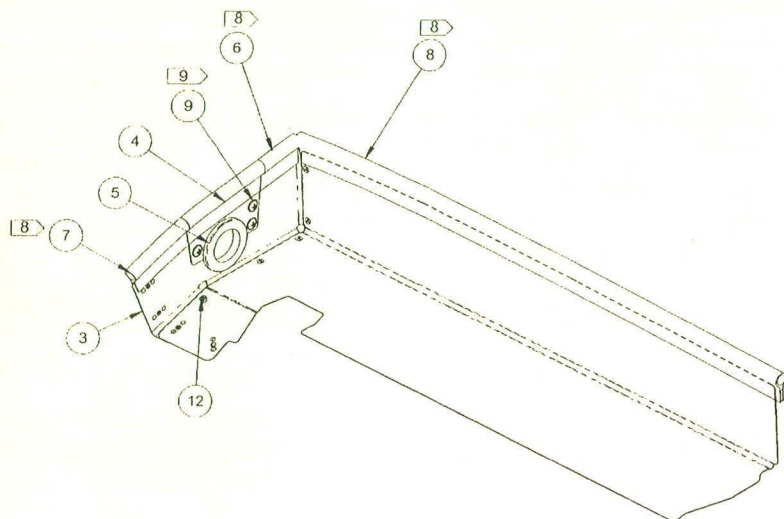
4

3

2

1

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE



RELEASED
R 2012 05-02

D4434-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
- 9) TORQUE SCREW TO 12-15 (in-lb)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4434	SHEET 2 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

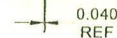
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
2012-03-02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA DRAWING NO. D4434 TITLE COVER ASSEMBLY <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS THE PROPERTY OF DART AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT MAY NOT BE USED FOR ANY PURPOSE OR CONTAINED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. B
DRAWN	RF		SHEET 7 OF 15
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>E</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.02.22		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries